



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200
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D3535-25
Job Sheet 186056



Part No: D3535-25

Job Qty: 6 ea

Part Name: Wearplate Center



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/9/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: URF 16-638 DWG REV B U/R IPP Rev:A New Issue 07-02-15 JLM IPP Rev:B As per Rev B 07-08-31 JLM
Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		11/23/18	0.00	0.40	Waterjet - Flow		SS 18/11/18
110	QC	6 pcs		11/23/18	0.00	0.00	QC2 Waterjet-2		SL 18/11/18
120	QC	6 pcs		11/23/18	0.00	0.00	QC8-2		38
130	Brake NC	6 pcs		11/23/18	0.12	0.25	Brake NC 1		SB 3-89 DAS
140	QC	6 pcs		11/23/18	0.00	0.00	QC5		38
150	Powdercoat	6 pcs		11/23/18	0.00	0.10	Powdercoat3		BED 18-11-2018
160	QC	6 pcs		11/23/18	0.00	0.00	QC3		DEC 12 2018 68
170	Packaging	6 pcs		11/23/18	0.00	0.00	Packaging3-1	ST602	DAS DEC 12 2018 9-89
180	QC21-SA	6 Ea		11/23/18	0.00	0.00	QC21		21 DEC 12 2018

M138839 START: 1:00 TEMP: 300° FINISH: 2:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	3.3000 sf (.55 ea)	100-Waterjet - Flow - 1	5090402

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S20GA	3	210	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	1.885inches ± 0.010	1.895 1.875	1.883	
2	Wearshoe	1.937inches ± 0.010	1.947 1.927	1.940	
3	Wearshoe	1.450inches ± 0.010	1.460 1.440	1.452	
4	Wearshoe	5.450inches ± 0.010	5.460 5.440	5.453	
5	Wearshoe	10.900inches ± 0.010	10.910 10.890	10.900	
6	Wearshoe	16.350inches ± 0.010	16.360	16.330	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																	
Date : _____		QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																															
En DART AEROSPACE Container No: S126830 Part: D3535 - 25 Job No: 186056 Serial No/Batch: S126830 Revision: C Inspector: _____ Exp Date: _____ Instructions: URF16 - 638 Date: 11/12/18 Equipment <table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:20%;">Handling/Pre</td> <td style="width:20%;">☐</td> <td style="width:20%;">Training</td> <td style="width:20%;">☐</td> <td style="width:20%;">Crimp/Kink/Ripple/wave</td> <td style="width:20%;">☐</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> <td>Cuffs</td> <td>☐</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> <td>Crushing</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> <td>Heat Treat</td> <td>☐</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> <td>Wave/Twist in Tube</td> <td>☐</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> <td>Marks/Chatter</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> <td colspan="2" rowspan="2">OTHER : _____</td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> </tr> </table>						Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/wave	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____		Misidentified	☐	Past Due	☐
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			16.340	
7	Wearshoe	21.800inches ± 0.010	21.810 21.790	21,800
8	Wearshoe	0.188inches $+ 0.005$ $- 0.001$	0.193 0.187	0,192
9	Wearshoe	12.750inches ± 0.010	12.760 12.740	12,750
10	Wearshoe	6.750inches ± 0.030	6.780 6.720	6,754
11	Wearshoe	6.000inches ± 0.030	6.030 5.970	6,003
12	Wearshoe	0.300inches ± 0.010	0.310 0.290	0,304
13	Wearshoe	0.300inches ± 0.010	0.310 0.290	0,305
14	Wearshoe	0.038inches ± 0.010	0.048 0.028	0,036

Plex 11/9/18 8:23 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
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